

Work Order ID 74105

Wednesday, September 21, 2011 1:29:21 PM



Page 1

Item ID: D3909-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/21/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3909

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EB 11/10/26 (3)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg
Trim rivet to 1.185" long

EB 11/10/26 (3)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/10/26

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74105

Wednesday, September 21, 2011 1:29:21 PM



Page 2

Item ID:	D3909-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Crosstube Lug Assembly, Fwd					
Start Date:	9/21/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	9/30/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>47/</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Handwritten notes:
n10/28
n10/28
11-10-28 (3)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 1:29:30 PM

Page 1

Work Order ID: 74105

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/21/2011





Required Date: 9/30/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revB DD 10.04.20 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-6  Lanyard Assembly		Manufactured	No			100	Each	16.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST020				16					
				70920				4					
				73324				12					
D3909-1  Lug Plate, Fwd Crosstube		Manufactured	No			100	Each	13.0000	2	6			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST090				13					
				73429				13					
D3909-3  Fwd Lower Attach Arm		Manufactured	No			100	Each	5.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST081				5					
				57819				1					
				65628				4					
D3909-5  Eyebolt Stud		Manufactured	No			100	Each	1.0000	1	3			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST091				1					
				65629				1					

EP 11/10/26

EP 11/10/26

EP 11/10/26

EP 11/10/26
B 73472
(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 3.00

Required Qty: 3.00

D3910-1
Crosstube Lug

Manufactured No

100 Each 34.0000

2

6

Location

Loc Qty

Loc Code

ENG

2

70160

2

st507

32

68263

2

73527

30

D3917-1

Manufactured No

100 Each 15.0000

2

6

Washer

Location

Loc Qty

Loc Code

ST

15

72710

15

AN3C12A

Purchased No

100 Each 100.0000

4

12

Bolts

Location

Loc Qty

Loc Code

ST351

100

117514

4

118112

5

118422

17

118451

24

118838

50

AN3C13

Purchased No

100 Each 41.0000

1

3

Bolt

Location

Loc Qty

Loc Code

ST351

41

114714

41

W/O:		WORK ORDER CHANGES					
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Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 3.00

Required Qty: 3.00

MS17984-C413 Purchased No
PIN, QUICK RELEASE

Location	Loc Qty	Loc Code
ST315	11	
114340	1	
118612	10	

11.0000 1 3
34/10/26

4M18
MS20615-4M20 Purchased No
RIVET

Location	Loc Qty	Loc Code
GA	160	
117071	30	
118571	130	

160.0000 3 9
34/10/26
M118077
(9A)

AN310C3 Purchased No
Castellated Nut

Location	Loc Qty	Loc Code
ST349	39	
114714	39	

39.0000 1 3
34/10/26

MS21043-3 Purchased No
Nut

Location	Loc Qty	Loc Code
FG	72	
103691	72	
ST301	1010	
118077	30	
118614	500	
118686	480	

1,082.000 4 12
34/10/26
12

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, September 21, 2011 1:29:31 PM

Page 4

Work Order ID: 74105

Parent Item: D3909-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 9/21/2011

Required Date: 9/30/2011

Start Qty: 3.00

Required Qty: 3.00

MS24665-151

Purchased

No

100

Each

414.0000

1

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

414

17566

414

NAS1149C0332R

Purchased

No

100

Each

4,099.000

8

24



Washer

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

4092

116304

55

117460

18

117887

169

118078

2

118179

78

118354

3770

NAS1149C0363R

Purchased

No

100

Each

4,020.000

2

6



Washer

Location

Loc Qty

Loc Code

ST297

4020

114742

4020

EPH/10/26

3
EPH/10/26

M119124
24X

6
EPH/10/26
6

Wednesday, September 21, 2011 1:29:31 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

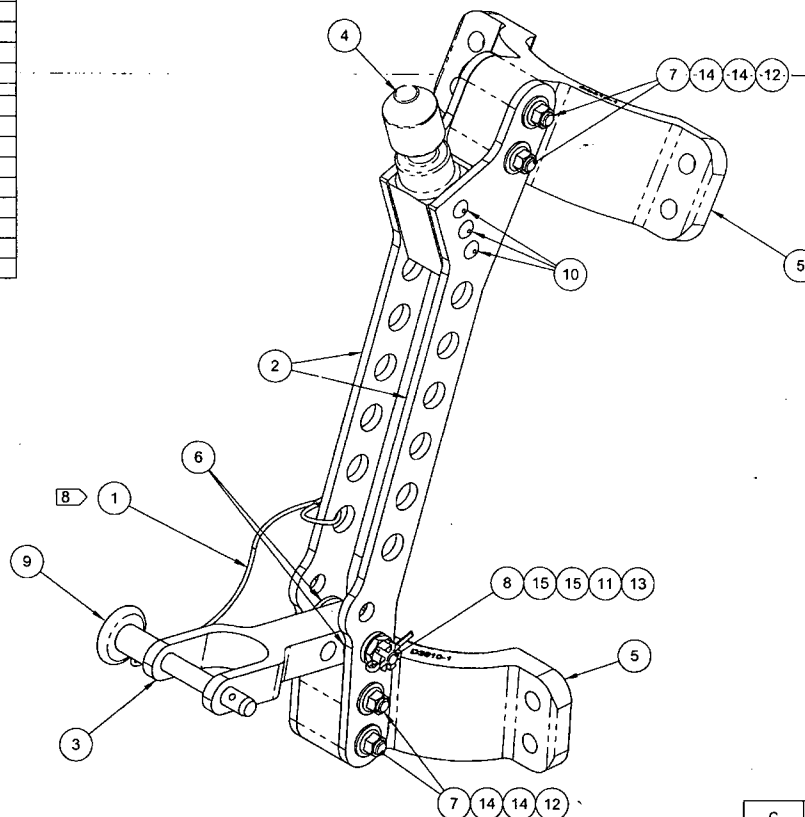
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3909-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	2	D3909-1	FWD X-TUBE LUG PLATE
3	1	D3909-3	FWD LOWER ATTACH ARM
4	1	D3909-5	EYEBOLT STUD
5	2	D3910-1	X-TUBE LUG
6	2	D3917-1	WASHER
7	4	AN3C12A	BOLT
8	1	AN3C13	BOLT
9	1	MS17984-C413	PIP PIN
10	3	MS20615-4M20	RIVET
11	1	AN310C3	NUT - CASTELLATED
12	4	MS21043-3	NUT
13	1	MS24665-151	COTTER PIN
14	8	NAS1149C0332R	WASHER
15	2	NAS1149C0363R	WASHER



D3909-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.81 lbs
- 8) ATTACH D2690-6 TO D3909-1 BY LOOPING AROUND LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413 PIP PIN'S RING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74105

RELEASED
2010-08-04

C	ITEM #4: 1.50 WAS 1.30 (ZN B5-S), 2.88 WAS 2.68 (ZN B6-S); WEIGHT AFFECTED (D3909-041-5).	MB	10.06.18
B	BOM: ADDED ITEM 15 QTY 2 NAS1149C0363R ADDED, ITEM 14 QTY 8 WAS 10, SHT 5, D3909-5 REVISED, SECTION A-A & DIM Ø0.650 REMOVED, SIDE VIEW ADDED, DIM: 2.68 WAS 2.38 REF, 1.30 WAS 1.00, 0.250 WAS 0.220, R0.06 WAS R0.05, WEIGHT REVISED.	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3909	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	FWD X-TUBE LUG ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3910-1
X-TUBE LUG
2 PL

D2690-6
LANYARD

MS17984-C413
PIP PIN

D3917-1
WASHER

D3909-5
EYEBOLT STUD

MS20615-4M20
RIVET
3 PL

D3909-1
FWD X-TUBE LUG PLATE
2 PL

D3909-3
FWD LOWER ATTACH ARM

AN3C12A BOLT
NAS1149C0332R WASHER, 2X
MS21043-3 NUT
4 PL

AN3C13 BOLT
NAS1149C0363R WASHER, 2X
AN310C3 NUT - CASTELLATED
MS24665-151 COTTER PIN

D3909-041 FWD X-TUBE LUG ASSY

RELEASED
2010-08-04

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.06.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

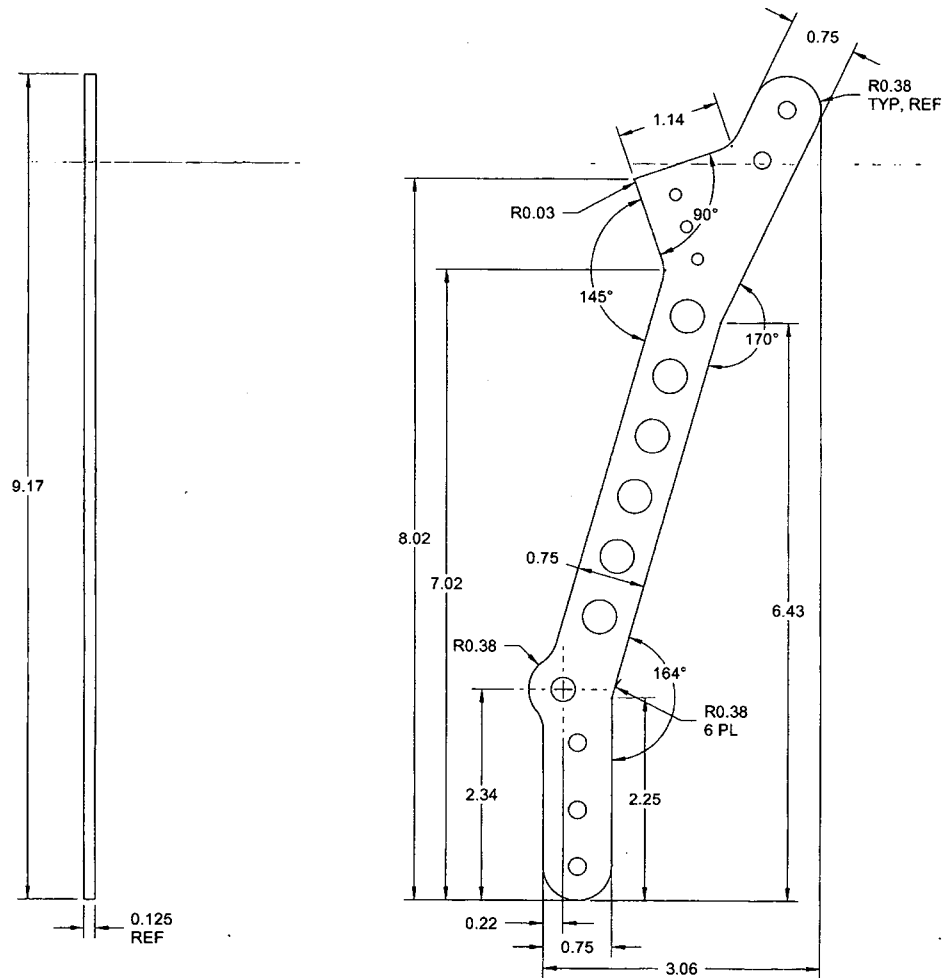
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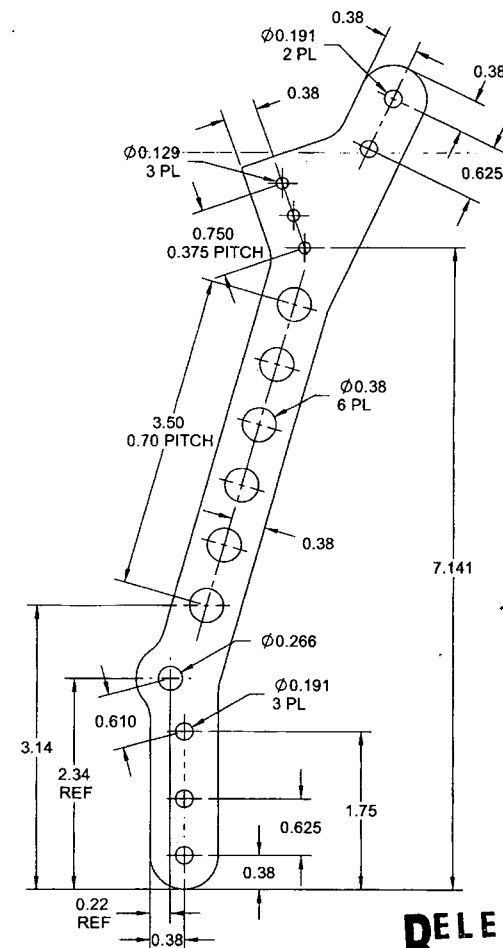
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NOTE: Date & initial all entries



D3909-1 FWD X-TUBE LUG PLATE



(SUPPLEMENTAL VIEW)

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY.	NTS
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RELEASED
2010-08-01
MA

174185

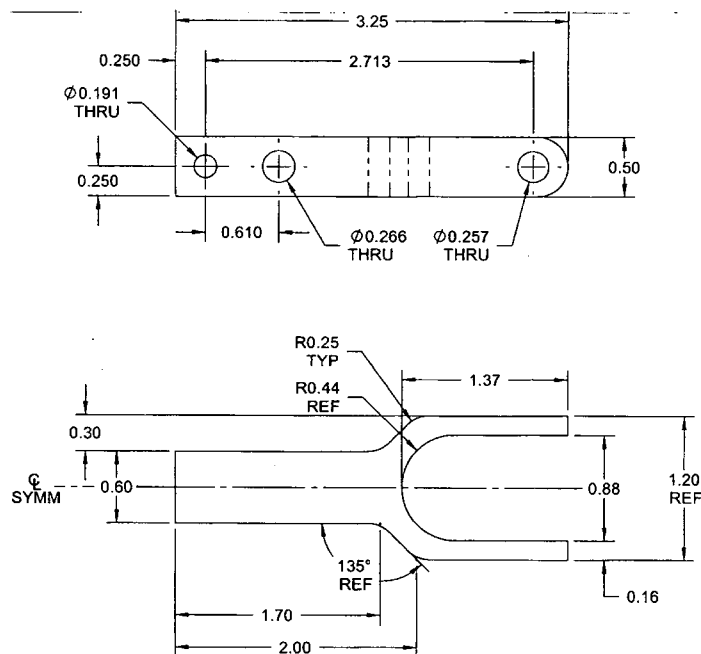
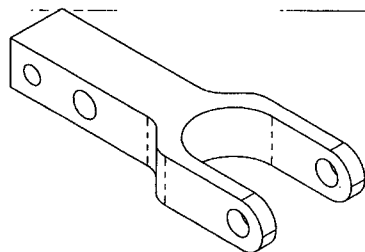
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3909-3 FWD LOWER ATTACH ARM

174105

RELEASED
2010-08-06

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A582 OR ASTM A276 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 4 OF 5
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DE APPR. --		FWD X-TUBE LUG ASSY	NTS
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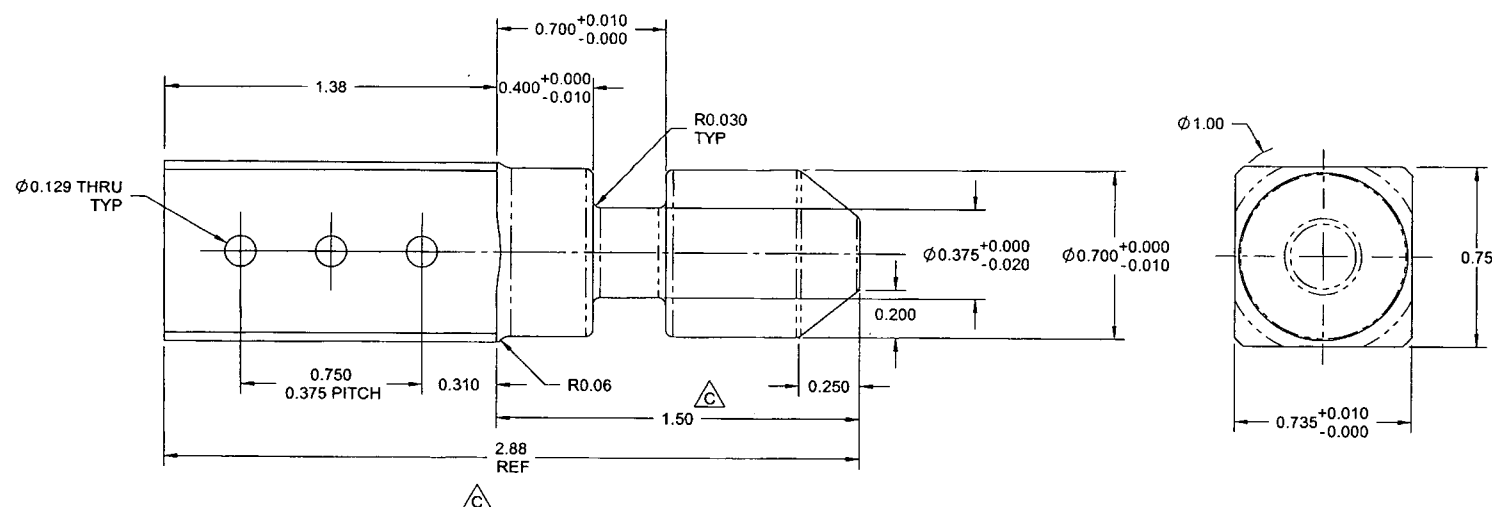
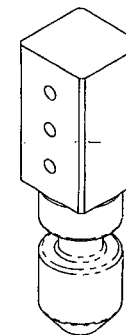
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D3909-5 EYEBOLT STUD

174105

RELEASED
2010-08-04

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR PER ASTM A582 OR ASTM A276 PER DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3909-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3909	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NT
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